



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 186598



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No: AIRBUS

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/25/19	1/25/19	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs	1/25/19	1/25/19	0.00	10.00	Large Fab 2		SLU
120	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC9		SLU
130	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC5		SLU
140	HandFinish	10 pcs	1/25/19	1/25/19	0.00	1.87	HandFinish1		SA 19/01/08
150	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC7-2		SLU
180	Large Fab	10 pcs	1/25/19	1/25/19	0.00	10.00	Large Fab 2		DAS
190	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC10		JAS 38
200	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC5		38 2-89
210	HandFinish	10 pcs	1/25/19	1/25/19	0.00	1.87	HandFinish1		DR 19/01/11
220	Powdercoat	10 pcs	1/25/19	1/25/19	0.00	2.98	Powdercoat1		BEI 19-01-14
230	HandFinish	10 pcs	1/25/19	1/25/19	0.00	1.87	HandFinish3	(XORH)	DR 19-01-12
240	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC3		38
250	Packaging	10 pcs	1/25/19	1/25/19	0.00	0.00	Packaging1-3		69 38
260	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC4		69 38
270	Packaging	10 pcs	1/25/19	1/25/19	0.00	0.00	Packaging3-1		69 38
275	DC	10 pcs	1/25/19	1/25/19	0.00	0.00	DC		JAN 1 19
280	QC21-FG	10 Ea	1/25/19	1/25/19	0.00	0.00	QC21		JAN 1 19

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M138872 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138872 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 12:22 OVEN TEMPERATURE: 350° FINISH TIME: 1:25

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

M138877

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	8125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	8125734
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5138869

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

5141119
9128757
117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
	MS20600-AD4W4	160	2,558	0
250-Packaging	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.

Plex 11/19/18 8:38 AM Dart.lajeunesse.marie

7419

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐				
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Large Fab ☐	Composite ☐	Supplier ☐																						
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																				
Description Work Order Deviation		Disposition		Completed By																				
 Container No: S139447 Part: D350-591-312 Job No: 186598 Serial No/Batch: S139447 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-6 Issue 1d, FAA STC SH967NE 04/12/21, BRAZIL 1				Lead hand / Supervisor Approval Verification																				
				QC / QA Coordinator Approval																				
		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Misabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>			☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Misabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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Job Sheet 186598



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

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Due Date: 1/25/19

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Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/19	0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SL
120	QC	10 pcs		1/25/19	0.00	0.00	QC9		SL
130	QC	10 pcs		1/25/19	0.00	0.00	QC5		SL
140	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		SA 19/01/08
150	QC	10 pcs		1/25/19	0.00	0.00	QC7-2		SL
180	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SL
190	QC	10 pcs		1/25/19	0.00	0.00	QC10		SL
200	QC	10 pcs		1/25/19	0.00	0.00	QC5		SL
210	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		SL
220	Powdercoat	10 pcs		1/25/19	0.00	2.98	Powdercoat1		SL
230	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish3		SL
240	QC	10 pcs		1/25/19	0.00	0.00	QC3		SL
250	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging1-3		JAN 10 2019
260	QC	10 pcs		1/25/19	0.00	0.00	QC4		SL
270	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging3-1		SL
275	DC	10 pcs		1/25/19	0.00	0.00	DC		SL
280	QC21-FG	10 Ea		1/25/19	0.00	0.00	QC21		SL

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M1358 72 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109
275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	3125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	3125734
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5138869

J03 186598

007400

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5141119
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5128757
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	117999
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5101329
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5115326
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5099500
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	5132811
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5139323
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	5121768
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	5113205
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	5136112
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5132364
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5129920
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5093592
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5107782
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5129985
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5050953

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
	MS20600-AD4W4	160	2,558	0
250-Packaging	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.